FORMING TOOLS

DealTech
All Around Sheet Metal Machines

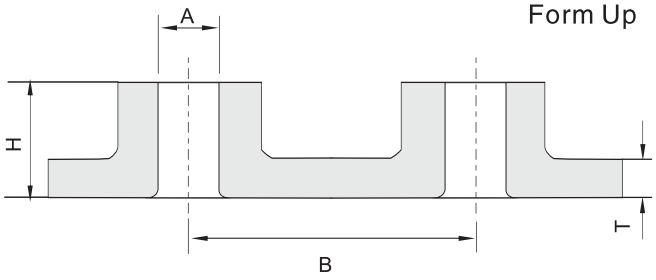
EXTRUSION TAPPING

Prepunch size (Stainless steel)

unit: mm [inch]

Extrusion		Thickness: T			
Size	øA	0.6 [0.02]	0.8 [0.03]	1.0 [0.04]	1.2 [0.05]
M2.6	2.21 [0.09]	1.3 [0.05]	1.3 [0.05]	1.3 [0.05]	
M3	2.60 [0.10]	1.3 [0.05]	1.3 [0.05]	1.6 [0.06]	1.8 [0.07]
M4	3.40 [0.13]		2.0 [0.08]	2.0 [0.08]	2.0 [0.08]
M5	4.30 [0.17]			2.3 [0.09]	2.3 [0.09]
M6	5.10 [0.20]			3.0[0.12]	3.0[0.12]

Form Up



Machine ____ A ____
Material ____ B ____
H ____ T ____

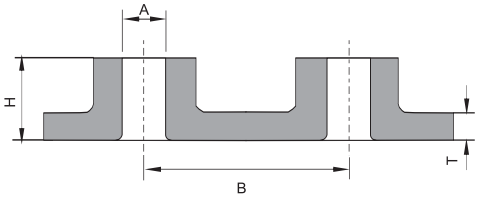
Prepunch size (Mild steel, Aluminum)

unit: mm [inch]

Extrusion		Thickness: T			
Size	øA	0.6 [0.02]	0.8 [0.03]	1.0 [0.04]	1.2 [0.05]
M2.6	2.21 [0.09]	1.3 [0.05]	1.3 [0.05]	1.3 [0.05]	
M3	2.60 [0.10]	1.3 [0.05]	1.3 [0.05]	1.6 [0.06]	1.8 [0.07]
M4	3.40 [0.13]		2.0 [0.08]	2.0 [0.08]	2.0 [0.08]
M5	4.30 [0.17]			2.3 [0.09]	2.3 [0.09]
M6	5.10 [0.20]			3.0[0.12]	3.0[0.12]

- Need prepunch
- Give tool enough time to strip
- Replaceable insert design on extrusion
- Form up & Form down
- Max. thickness
  Mild steel 2.3mm [0.09"]
  AL 2.0mm [0.08"]
  Stainless steel1.2mm [0.05"]

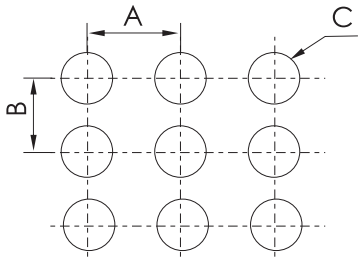
EXTRUSION



Machine ____ A ____
Material ____ B ____
H ____ T ____

1.Need prepunch
2.Form up & Form down
3.Max. thickness
M.S & AL 2.0mm [0.08"]
S.S 1.2mm [0.05"]
4.Forming Hight: H≥2T

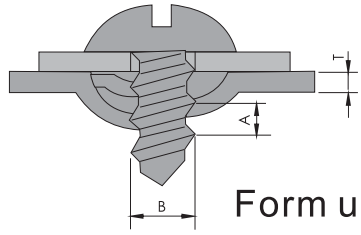
CLUSTER



Machine ____ A ____ C ____
Material ____ B ____ T ____

- Space of holes must be over 3.2mm [0.125"]or 2 x T

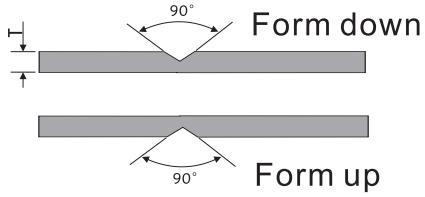
THREAD FORM



Machine ____ A ____
Material ____ B ____ T ____

- Form up, Form down
- Thickness：0.5mm~1.2mm [0.02"~0.05"]

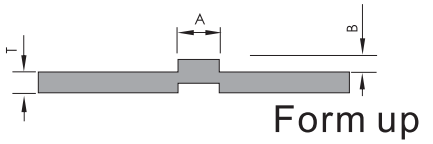
CENTER POINT



Machine ____
Material ____ T ____

- Forbid punching without sheet
- Adjust the height of the tool to change the depth when punching
- Form up & Form down
- Angle: 90 degree, Max. thickness: 6.0mm [0.236"]

HALF SHEAR



Machine ____ A ____
Material ____ B ____ T ____

- Form up & Form down
- Max. B size: 0.6 x T

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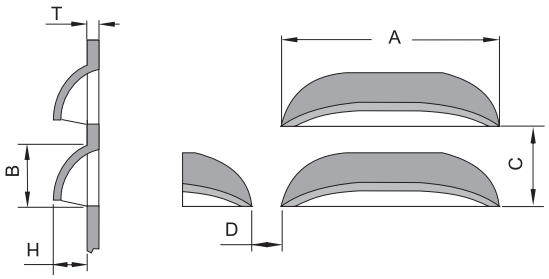
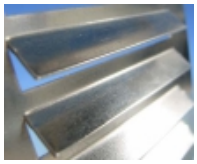
CLOSE LOUVER

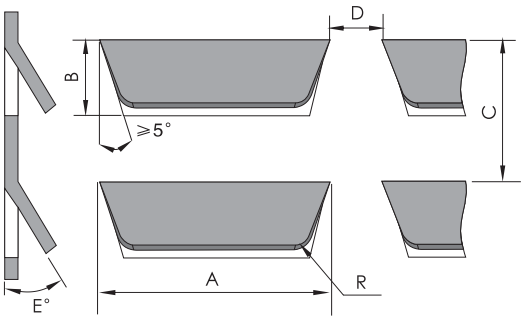


Machine____ A ____ D ____
Material____ B ____ H ____
C ____ T ____

1.Tooling is made for specific sheet metal thickness
2.Give tool enough time to strip
3.Adjust length without shim, replaceable insert
4.Form up only

OPEN LOUVER

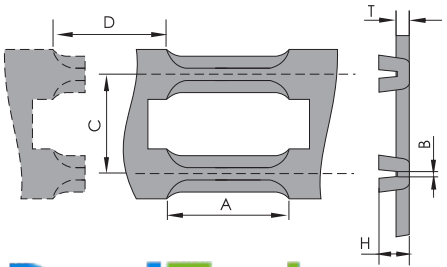




Machine____ A ____ D ____
Material____ B ____ E ____
C ____ T ____ R ____

1.Tooling is made for specific sheet metal thickness
2.Give tool enough time to strip
3.Consider the moving direction of the material
when programing
4.Adjust length without shim, replaceable insert
5.Form up only

CARD GUIDE



Machine____ A ____ D ____
Material____ B ____ H ____
C ____ T ____

- Tooling is made for specific thickness
- Adjust length without shim, replaceable insert
  Forming Height≤2 T, or will be deformation easily

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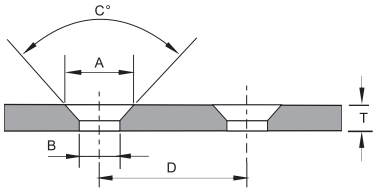
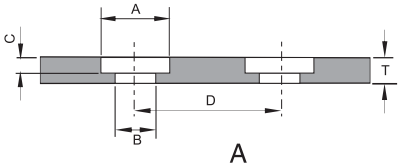
COUNTERSINK



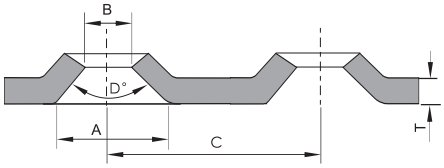
Machine_____ A _____ D _____
Material _____ B _____ T _____
C _____



Machine_____ A _____ D _____
Materia _____ B _____ T _____
C _____

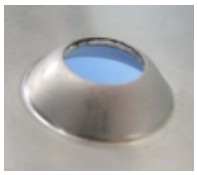
- Need prepunch
- Adjust prepunch size to get different depth
- Form up & Form down
- Min. thickness: T≥1. 0mm [0.04"]

EMBOSS COUNTERSINK

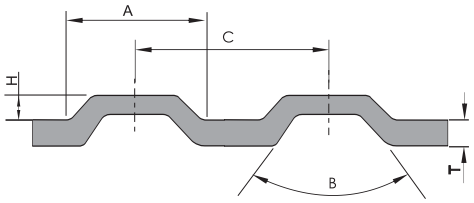


Machine_____ A _____ D _____
Material_____ B _____ T _____
C _____

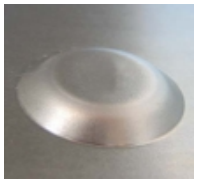
- Suggest using prepunch
- Form up only



EMBOSS

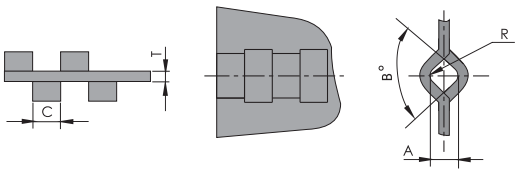


Machine_____ A: _____ H: _____
Material_____ B: _____ T: _____
C: _____



- Escape clamp or punching hole
- Can form in Round or Shape
- Form up & Form down

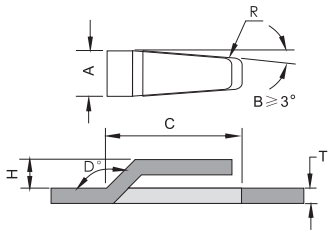
THREAD LOOP



Machine____ A ____
Material____ B ____ R ____
C ____ T ____

- Angle B = 90°
- Please fill in the left form

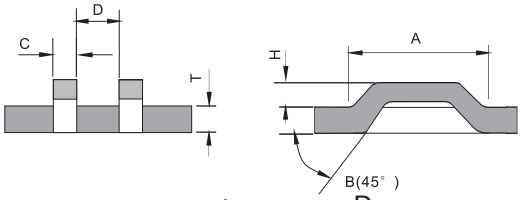
LANCE & FORM



Machine____ A ____ C ____ R ____
Material____ B ____ D ____ H ____ T ____

- Tooling is made for specific thickness, can not use thicker material, otherwise the tool will be damaged.
- Please fill in the left form

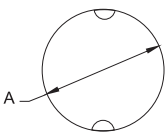
BRIDGE



Machine____ A ____ D ____
Material____ B ____ H ____
C ____ T ____

- Can be designed in single or double bridge
- Form up & Form down
- Width of the Bridge C≥2T and C≥1.8mm [0.07"]

KNOCKOUT



Machine____
Material____ A ____ T ____

- For small thickness range only
- Changeable insert for another size, save cost

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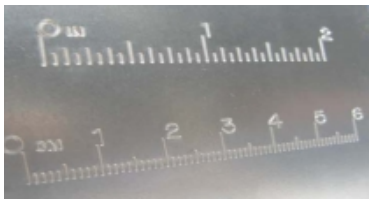
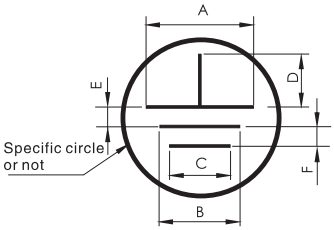
All Around Sheet Metal Machines

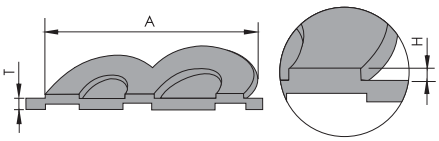
MULTI–SCRIBE



- Forbid punching without sheet
- Required special control program for the machine
- Form down only

STAMPING





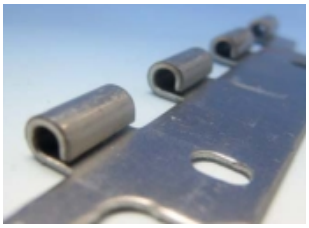
Machine_____ A _____ T _____
Material_____ H _____

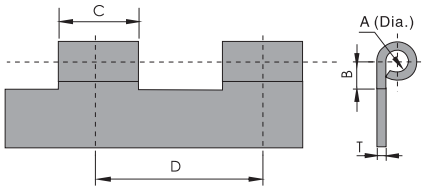
- Form up & Form down
- Please fill in the above form

Machine_____ A _____ D _____ G(width)_____
Material_____ B _____ E _____ H(depth)_____
C _____ F _____

1. Forbid punching without sheet
2. Adjust the height of the tool to change the depth when punching
3. Form up or Form down
4. Please fill in the above form

HINGE



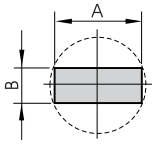


Machine_____ A _____ D _____
Material_____ B _____ T _____
C _____

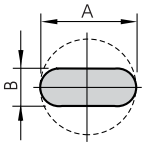
1. Tooling is made for specific sheet metal thickness
2. Need prepunch
3. First for curling, second for forming
4. Form up only
5. Thickness: T ⩽ 2.0mm [0.08"] (Mild steel)
   T ⩽ 1.5mm [0.06"] (Stainless steel)
6. Please fill in the left form

SHAPE CLASSES

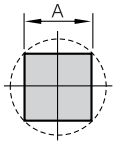
STANDARD SHAPE



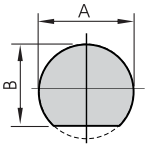
Code: RE
Name: Rectangle
Size: B/A



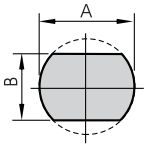
Code: OB
Name: Oblong
Size: B/A



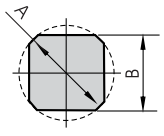
Code: SQ
Name: Square
Size: A



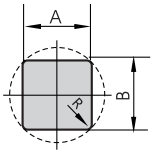
Code: SD
Name: Single D
Size: B/A



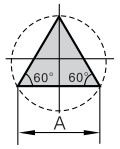
Code: DD
Name: Double D
Size: B/A



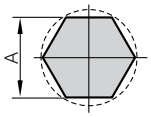
Code: QD
Name: Quad D
Size: B/A



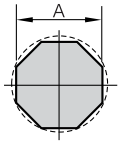
Code: QR
Name: Quad R
Size: B/A/R



Code: ET
Name:
Equilateral Triangle
Size: A

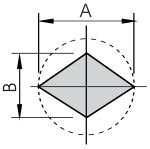


Code: HX
Name: Hexagon
Size: A

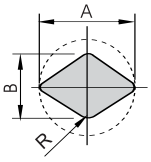


Code: OT
Name: Octagon
Size: A

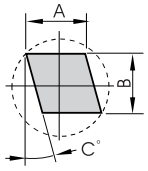
GROUP A



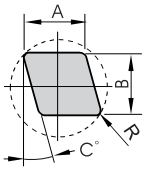
Code: A0
Name: Diamond
Size: B/A



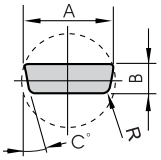
Code: A1
Name: Diamond
Size: B/A/R



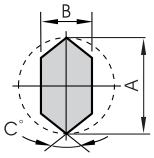
Code: A2
Name: Diamond
Size: B/A/C



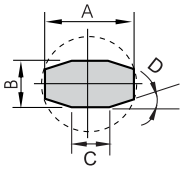
Code: A3
Name: Diamond
Size: B/A/C/R



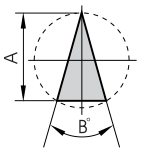
Code: A4
Name:
Cable Connector
Size: B/A/C/R



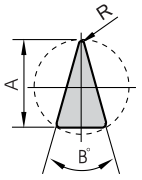
Code: A5
Name: Six Edges
Size: B/A/C



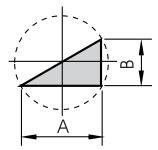
Code: A6
Name:Eight Edges
Size: C/B/A/D



Code: A7
Name: Triangle
Size: B/A

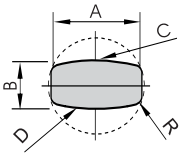


Code: A8
Name:Triangle w/R
Size: A/B/R

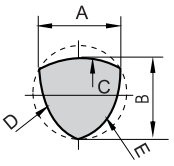


Code: A9
Name:
Right Triangle
Size: B/A

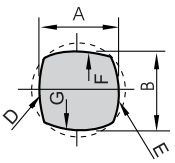
GROUP B



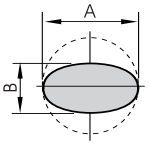
Code: B0
Name: Double R
Size: B/A/C/D/R



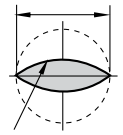
Code: B1
Name: Tri-R
Size: B/A/C/D/E



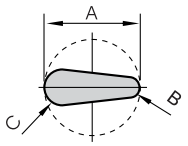
Code: B2
Name: Quad-R
Size: B/A/D/E/F/G



Code: B3
Name: Ellipse
Size: B/A/C/R



Code: B4
Name: Football
Size: A/B



Code: B5
Name: Key Hole
Size: A/B/C

SPECIAL SHAPE

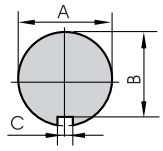
Special shape follows the attached drawing

CODE: FT

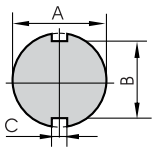
DealTech
All Around Sheet Metal Machines

SAME STATION TOOLING, SAME GROUP SHAPE, SAME PRICE!

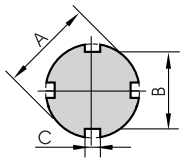
GROUP C



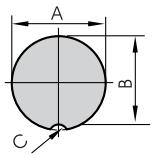
Code: C0
Name: Key Way
Size: C/B/A



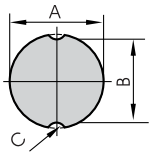
Code: C1
Name:
Double Key Way
Size: C/B/A



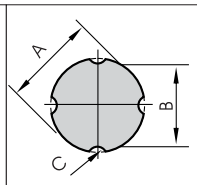
Code: C2
Name:
Quad Key Way
Size: C/B/A



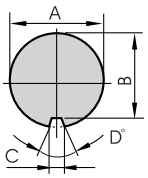
Code: C3
Name: Key Way
Size: C/B/A



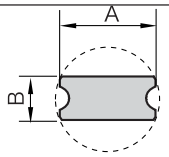
Code: C4
Name: Key Way
Size: C/B/A



Code: C5
Name: Key Way
Size: C/B/A

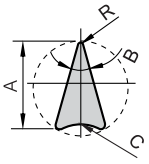


Code: C6
Name: Key Way
Size: C/B/A/D

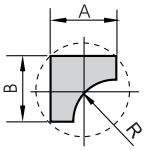


Code: C7
Name: Micro-joint
Size: B/A

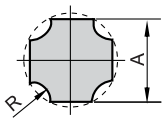
GROUP D



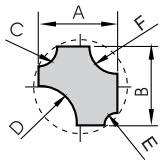
Code: D0
Name:Triangle w/R
Size: A/B/C/R



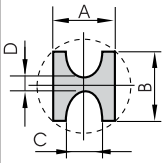
Code: D1
Name:
One way radius
Size: B/A/R



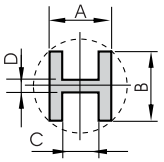
Code: D2
Name:
Four way radius
Size: A/R



Code: D3
Name:
Four way radius
Size: A/B/C/D/E/F

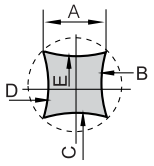


Code: D4
Name: H w/radius
Size: D/C/B/A

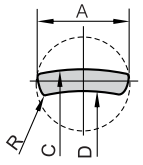


Code: D5
Name: H shape
Size: D/C/B/A

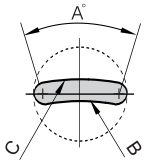
GROUP E F



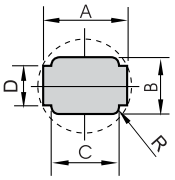
Code: E0
Name: Four radius
Size: A/B/C/D/E



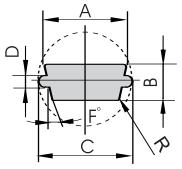
Code: E1
Name: Banana
Size: A/C/D/R



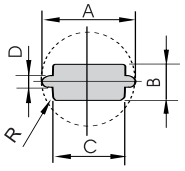
Code: E2
Name: Banana
Size: B/C/A



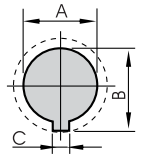
Code: E3
Name: Connector
Size: D/B/C/A/R



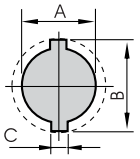
Code: E4
Name: Connector
Size: D/B/A/C/F/R



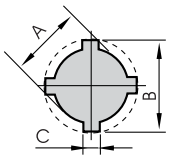
Code: E5
Name: Connector
Size: D/B/C/A/R



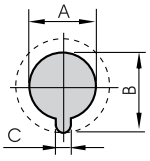
Code: E6
Name: Key Hole
Size: C/A/B



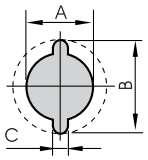
Code: E7
Name: Key Hole
Size: C/A/B



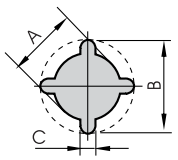
Code: E8
Name: Key Hole
Size: C/A/B



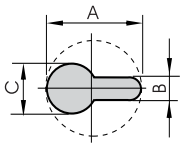
Code: F0
Name: Key Hole
Size: C/A/B



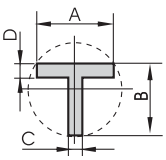
Code: F1
Name: Key Hole
Size: C/A/B



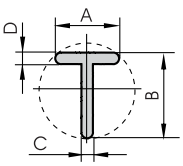
Code: F2
Name: Key Hole
Size: C/A/B



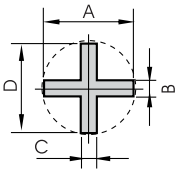
Code: F3
Name: Key Hole
Size: B/C/A



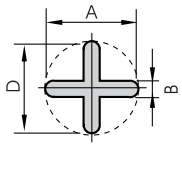
Code: F4
Name: T shape
Size: D/C/B/A



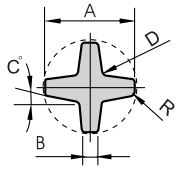
Code: F5
Name: T shape
Size: D/C/A/B



Code: F6
Name: Cross
Size: C/B/D/A



Code: F7
Name: Cross
Size: B/A/D



Code: F8
Name: Cross
Size: B/A/C/D/R

MACHINE GROUPS

A	B	C	D	E
CN 700	CN 901E	CN 1200S	TRUMATIC	SUNIMA T400
CN 900	CN 902	CN 1200A	20	TRUMATIC TRUMATIC
CN 701	CS 75	CS 15	20A	150K 202K
CN 901	CS 75.2	CS 20	202M	151K 225K
		CS 20 A		152K 235K
		MP25		180K 300K
		MP25D		180.2K 300LK
				180KD 300PK
				180LK 400K
				180.2LK

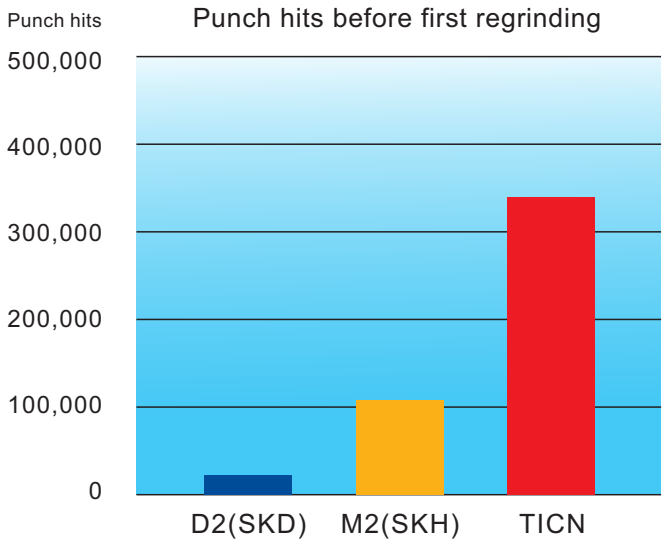
F	G	H	I	S
150W	TRUMATIC	TRUMATIC	TRUMATIC	MINIMA TIC
152W	20AW	500R	2000R	100
180W	202W	200R	2010R	TRUMATIC
180.2W	300W	190R	2020R	120R
180R	300LW	600L	3000–1300R	160R
180LW	300PW		3000–1600R	
180.2LW	300TOP		5000R	
ELX/SWIFT	400W		6000R	
185			1000R	
240				
240R				
250				
260R				

COATING TECHNOLOGY

PUNCHING CONDITION

- Good station alignment,qualified for punch tip symmetry,dowel pin size,width of guide slot
- Punch size square 6mm,take out and inspect,check wear on tip
- Sheet metal:stainless steel(SUS304),thickness:1.5mm
- Punching type:square nibbling,1.5mm step

TICN COATING
Strongly improve tooling durability



DealTech
All Around Sheet Metal Machines


Chuck


Insert


Punch


Die


Punch Blade
Die Blade


Alignment ring


Stripper


RP SERIES

RECIPIENT:	SENDER:
COMPANY:	END USER:
DEPT.:	TELEPHONE:
TELEPHONE:	FAX No.:
FAX No.:	PAGES:
SUBJECT:	DATE:

Trumpf Tool	☐ Sta. style ☐ Long style ☐ RP series ☐ Heavy duty ☐ Multi-tool						
No.	Station	Description	Size	Shape	Amount	Sheetmetal	Thickness	Remark

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